

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021739**Date Inspected:** 24-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector Brett W Rice was present during the times noted above for observations relative to the work being performed at ZPMC.

Bay 14 East

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Flux Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Zha Hai Feng.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

PCMK: DP-3102-001

Weld No: 249

Welder: 052696

WPS-B-T-2233-ESAB

PCMK: SEG-3011G

Weld No: 008

Welder: 037705

WPS-B-T-2233-ESAB

PCMK: SEG-3019L

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Weld No: 299, 301, 303, and 305

Welder: 051356

WPS-B-T-2233-ESAB

PCMK: SEG-3007P

Weld No: 024

Welder: 055564 and 055491

WPS-B-T-2232-ESAB

PCMK: SEG-3007AH

Weld No: 025 and 027

Welder: 050242

WPS-B-T-2233-ESAB

PCMK: SEG-3007AT

Weld No: 011 and 012

Welder: 020009

WPS-B-T-2233-ESAB

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Zha Hai Feng.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

PCMK: DP-3163-001

Weld No: 216 and 218

WR: 20222

Welder: 215553

WPS-345-SMAW-2G(2F)-FCM-Repair-1

PCMK: DP-3163-001

Weld No: 020

WR: 20222

Welder: 050969

WPS-345-SMAW-2G(2F)-FCM-Repair-1

PCMK: DP-3163-001

Weld No: 212 and 213

WR: 20250

Welder: 037932

WPS-345-SMAW-2G(2F)-FCM-Repair-1

PCMK: DP-3163-001

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Weld No: 041

WR: 20271

Welder: 067656

WPS-345-SMAW-2G(2F)-FCM-Repair-1

PCMK: SEG-3019U

Weld No: 003

WR: 20270

Welder: 054013, 066418, and 044779

WPS-345-SMAW-2G(2F)-FCM-Repair-1

PCMK: SEG-3007E

Weld No: 066

WR: 20179

Welder: 069924

WPS-345-SMAW-2G(2F)-FCM-Repair-1

PCMK: SEG-3019R

Weld No: 158 and 159

Welder: 067610

WPS-B-P-2214-TC-U4b-FCM-1

PCMK: SEG-3007B

Weld No: 140

Welder: 216086

WPS-B-P-2213-B-U2-FCM-1

Bay 16

This QA Inspector observed the following work in progress for Bay 16.

ZPMC was using the Shielded Metal Arc Welding (SMAW) and Flux Cored Arc Welding (FCAW) process to weld the components as follows; SA-6007A~D, SA-6008A~H, SA-6009A and B, SA-6010A~L, SA-6011A and B, SA-6012A, SA-6013A, and SA-6015A~D.

ABF QC is identified as Peng Wen Jun.

Welding variables were not recorded by QC. This QA Inspector has written an incident report and is awaiting the outcome.

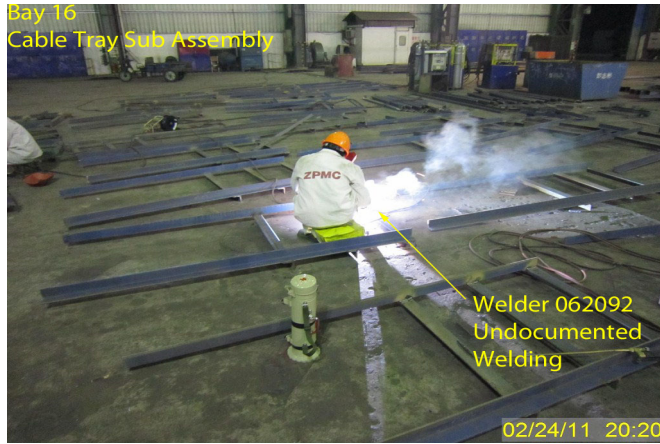
Bay 19

ZPMC was observed on this date performing grinding on various welds for PCMK BK-005A-002 and BK-004B-001. It was noted that during the grinding operation ZPMC was both cleaning the welds and grinding the welds to the appropriate contour

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Rice,Brett	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
